

5/30

DART AEROSPACE LTD		Work Order:	23793
Description: Bracket Assembly		Part Number:	D3121-144
Dwg: D3121 Rev. C		Qty:	15 <del>15</del> Kit(s) <del>15</del> 04.02.27

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	<i>JL</i>	05.07.12	14
2	MV	Cut blank: (1.000" x 2.000" ) 4.425" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-114			
3	MV	Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114	<i>EP</i>	05/08/11	14 P/D
4	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	05/08/11	15
5	MV	Deburr	<i>EP</i>	05/08/11	15
6	MV	Scribe batch number	<i>EP</i>	05/08/11	15
7	QC8	Second check	<i>EP</i>	05/08/11	15
8	GA	Assemble D3121-144 as per Dwg D3121: Pick: Qty Part Number Description Batch 2 D3121-21 Bolt <u>B23814</u> 2 D3121-241 Bearing Assembly <u>B218554</u>	<i>EP</i>	05/08/11	15
9	QC5	Inspect work to Step 8	<i>EP</i>	05/08/13	15
10	ST	Identify and Stock	<i>EP</i>	05/08/15	15
11	AC	Cost / part <u>75.76</u>	<i>EP</i>	05/08/17	15
12	DC	Close W/O <u>75.76</u> Inspect Level 21	<i>EP</i>	05/08/15	15

Rev	Date	Change	Revised By	Approved
AB	04.02.18	New issue	KJ/DS	<i>EP</i>

04.02.19

RELEASED  
04.02.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/08	#3	are PART SCRAP. Grooves (Slots) not centered. First Run. (0.025" off)		PART IS ACCEPTABLE RELATIONSHIP BETWEEN HOLES IS OK			05.08.11	
05/08/08	#3	are PART SCRAP mould in vise	JD 08/08/08	Scrap / destroy and Replace	E -108/08	JD 05/08/08	JD 08/08/08	JD 08/08/08

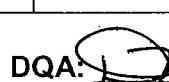
Part No: D3121-144

PAR #: \_\_\_\_\_

Fault Category: Production/machined parts

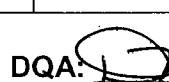
NCR: Yes

No

DQA: 

Date: 05/08/16

NOTE: Date &amp; initial all entries

QA: N/C Closed: 

Date: 05.08.16

DART AEROSPACE LTD		Work Order:	23793
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121	Rev: C2		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.081	✓	—		
0.300	+/-0.010	0.295	✓	—		
R0.375	+/-0.010	0.375	✓	—		
1.54	+/-0.030	1.543	✓	—		
0.350	+/-0.010	0.349	✓	—		
R0.250	+/-0.010	0.250	✓	—		
1.800	+/-0.030	1.802	✓	—		
Ø0.392	+0.002/-0.000	0.392	✓	—		
Ø0.201	+0.005/-0.000	0.201	✓	—		
0.100	+/-0.010	0.099	✓	—		
2.540	+/-0.010	2.536	✓	—		
1.590	+/-0.010	1.588	✓	—		
0.160	+/-0.010	0.160	✓	—		
0.400	+/-0.010	0.392	✓	—		
1.220	+/-0.010	1.222	✓	—		
1.600	+/-0.010	1.602	✓	—		
3.80	+/-0.030	3.804	✓	—		
1.800	+/-0.010	1.802	✓	—		
R0.500	+/-0.010	0.500	✓	—		
0.130	+/-0.010	0.124	✓	—		
3.41	+/-0.030	3.395	✓	—		
3.65	+/-0.030	3.648	✓	—		
2.24	+/-0.030	2.210	✓	—		
45°	+/-0.1°	45°	✓	—		
R0.250	+/-0.010	0.250	✓	—		
3.97	+/-0.030	3.969	✓	—		
R0.38	+/-0.030	0.38	✓	—		
Ø0.392	+0.002/-0.000	0.392	✓	—		
Ø0.201	+0.005/-0.000	0.201	✓	—		
0.100	+/-0.010	0.099	✓	—		
0.268	+/-0.010	0.268	✓	—		
R0.260	+/-0.010	0.260	✓	—		
0.080	+/-0.010	0.081	✓	—		
0.300	+/-0.010	0.295	✓	—		

RELEASED

DART AEROSPACE LTD	Work Order:	23793
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121	Rev: C2	Page 2 of 2

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	CR
Date:	05/08/09

Audited by:	<i>ml</i>
Date:	05/08/13

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-144	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	

RELEASED

11/05.05.06

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyJul 12, 2005  
02:29 pm

Work Order No : 0023793  
 Project Name : D3121-144  
 Project For : WK530  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3121-144  
 Description : Bracket Assembly  
 Manufactured : Yes  
 Amount Req'd : 14  
 Amount Done : 0  
 Start Date : 07-12-05  
 Est Finish Date : 07-30-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00